

Work Order ID 61060

August 5, 2010 8:15:46 AM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 8/05/10 Start Qty: 12.00



Cust Item ID:

Required Date: 8/09/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3414-1

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

B10-8-5

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-8-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/10/2010

214

Quality Control

130

0.00



Brake NC

Memo

0.00

8/10/2010

14

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

140

0.00



Large Fab

Memo

0.00

EL 10-8-9

214

Large Fab

1- Weld using location Jig DT8484 as per Dwg D3414

A/R S.S. welding rod Batch: M101744

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 61060

August 5, 2010 8:15:47 AM

Page 3

Item ID: D3414-041

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Revision ID:

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Start Date: 8/05/10 Start Qty: 12.00

Required Date: 8/09/10 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

10 PD 10.09.9

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Soloslor

114

170

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:15am
OVEN TEMPERATURE: 400°F
FINISH TIME: 7:45am

=) 10/08/10

K14

Work Order ID 61060

August 5, 2010 8:15:47 AM



Page 4

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 8/05/10 Start Qty: 12.00



Cust Item ID:

Required Date: 8/09/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/8/10 08 10 (14)

190

Identify as per dwg & Stock Location 473

0.00



Packaging

Memo

0.00

Packaging

10/8/10 14-2 SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10 MF 10-8-10

Picklist Print

August 5, 2010 8:15:44 AM

Page 1

Work Order ID: 61060

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 8/05/10

Required Date: 8/09/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

189.0000

0.155

1.86

2.2



304/316 0.100" Sheet



1810-8-9

Location

Loc Qty

Loc Code

MAT19

189

112611

29

113062

128

113077

32

112710

140

Each

24.0000

1

12

D3414-3

Manufactured

No



Lug



12 10-8-9

Location

Loc Qty

Loc Code

WA

24

52652

6

53355

19

6

8

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

61060

DART AEROSPACE LTD		Work Order: 77054
Description: Lug Bracket		Part Number: D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	.313	✓		V B 02	
1.19	+/-0.030	1.184	✓		V	
1.00	+/-0.030	1.009	✓		V	
3.38	+/-0.030	3.377	✓		V	
5.350	+/-0.010	5.351	✓		V	
6.23	+/-0.030	6.227	✓		V	
2.500	+/-0.010	2.499	✓		V	
0.37	+/-0.030	.367	✓		V	
0.100	+/-0.010	-102	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-8-5	Date: 10/08/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

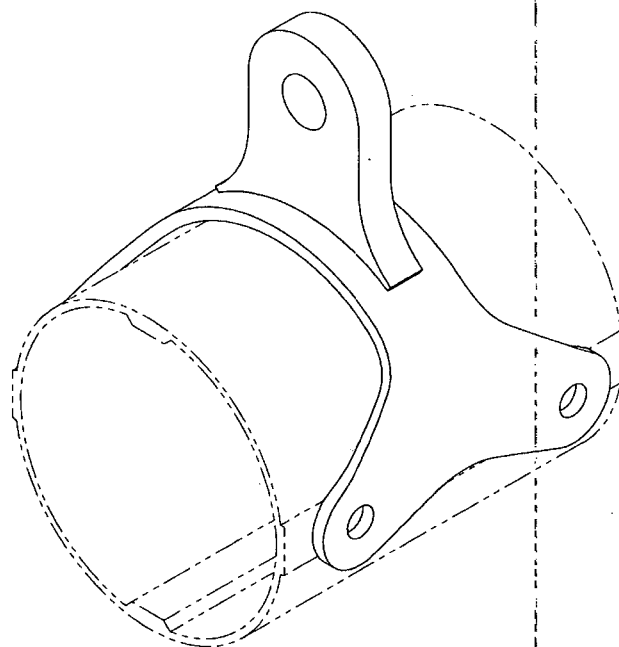
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

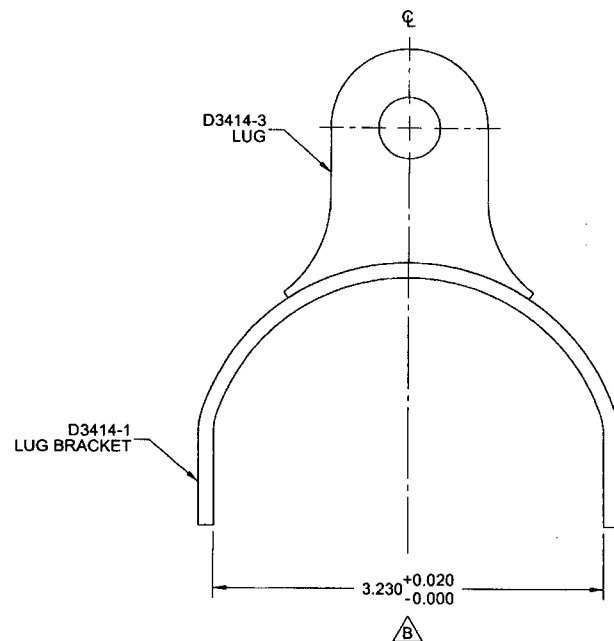
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

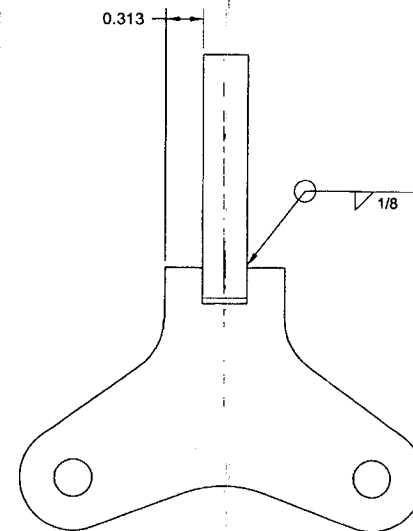
w/o broko

RELEASED
2/1/86/06/07

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	2	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



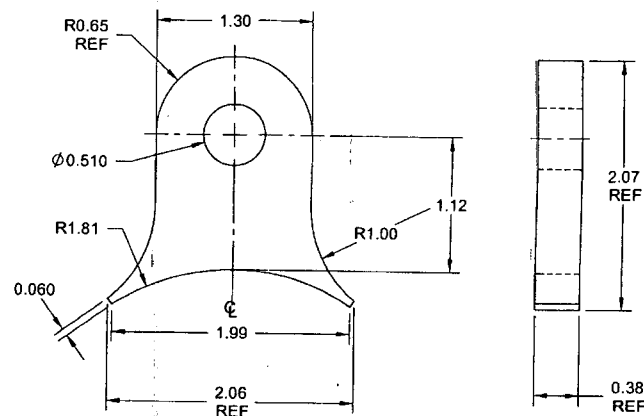
D3414-041 LUG ASSEMBLY



u/b 61060

RELEASED
04/12/17

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
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D3414-3 LUG

w/o 61060

RELEASE
69/10/06 MP

7) WEIGHT: N/A

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DRAWN	CP		SHEET 3 OF 3
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	09.06.17		